

Date: Tuesday, 07/04/2009 3:19:30 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD ADJUSTABLE BLADE SUPPORT ASSY
Job Number	: 47050		
Estimate Number	: 13435		
P.O. Number	:	Part Number	: PB674300111 GN
This Issue	: 07/04/2009 S.O. No. :	Drawing Number	: B6743001 P.8
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 07/04/2009 Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 45043	Material	:
Written By	:	Due Date	: 14/04/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 09-04-08</u>		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB6743001247	Inner Tube
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Inner Tube batch: <u>B 44985 = 1X</u> <u>SP 09.04.16</u>	
2.0	PB6743001249	Inner Tube Bushing
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Inner Tube Bushing batch: <u>B 44984 = 1X</u> <u>SP 09.04.16</u>	
3.0	PB6743001253	Gusset
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Gusset batch: <u>B 44983 = 1X</u> <u>SP 09.04.16</u>	
4.0	PB6743001254	Gusset
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Gusset batch: <u>B 44982 = 1X</u> <u>SP 09.04.16</u>	
5.0	PB674300167	PB67-43001-67
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) PB67-43001-67 batch: <u>45022 = 1X</u> <u>SP 09.04.16</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

SP 09.04.17 (1)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.04.17 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.04.17 (1)
is shorter than dwg / but does not have the pen.

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

HELICAL INSERT m111064

09.04.23

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- install helicol insert as per dwg

09.04.23

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02/04/23 (1)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

2/45

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

m18144

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

FL 09/05/05 (1)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 47050

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

11:30

OVEN TEMPERATURE:

320°

FINISH TIME:

12:00

FD 09/05/05 (1)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 09-05-5 (1)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

90 Degree Cover Plate

batch: B45762

EP 09/05/06

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

PB67-43001-83

batch: B47042

EP 09/05/06

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

batch: M110704

EP 09/05/06

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

batch: M11117

EP 09/05/06

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

EP 09/05/06 (1)

W/O:		WORK ORDER CHANGES					
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Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/06 (X)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: misc

lpl 09-05-06

(1)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/06 (X)

Job Completion



mf
09-05-06

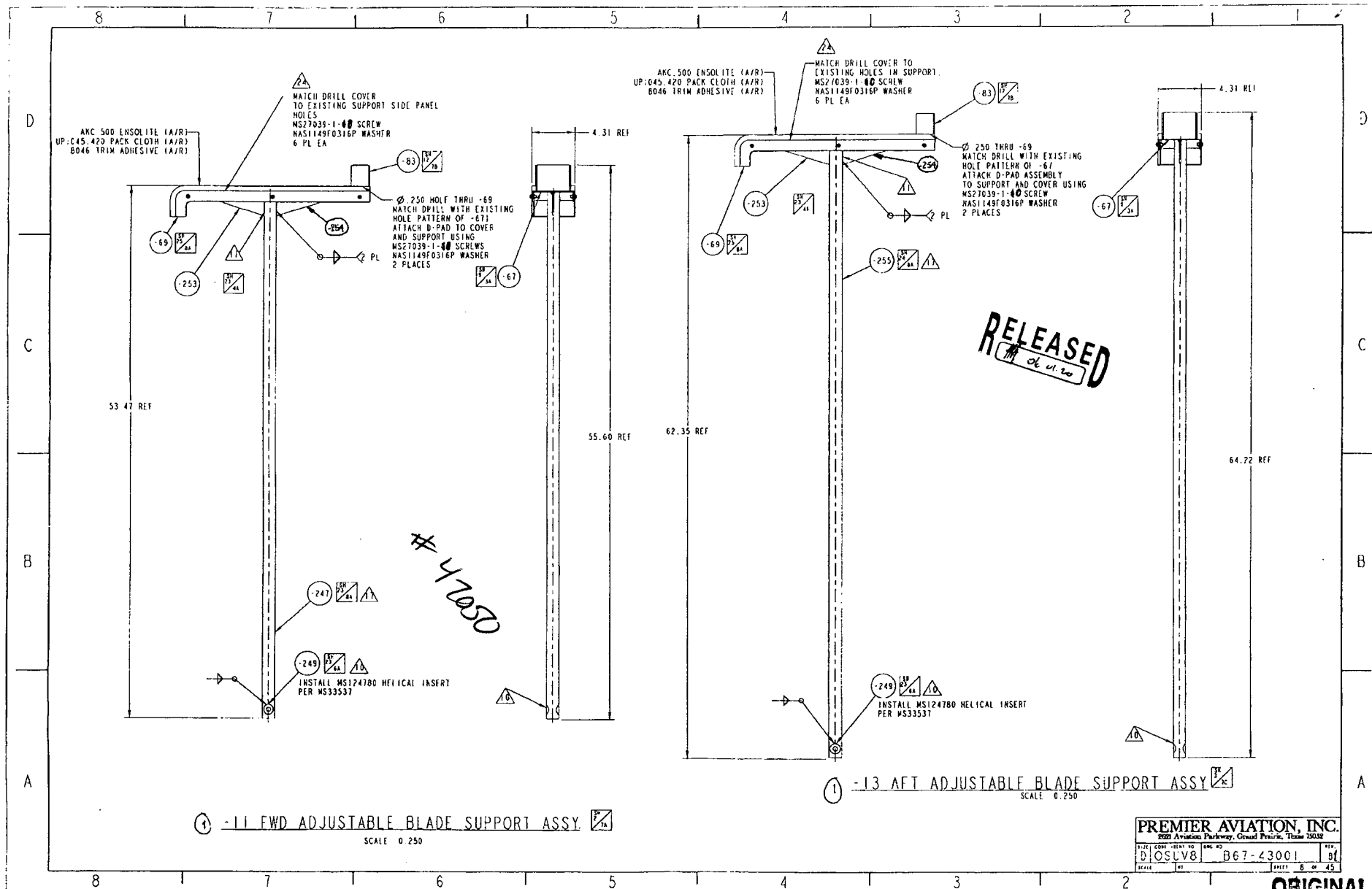
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NOTE: Date & initial all entries



PREMIER AVIATION, INC.
2001 Aviation Parkway, Grand Prairie, Texas 75052

SIZE	CON	REV	REV
D	CSLV8	B67-43001	81
SCALE	1:1	SHEET	8 OF 45

ORIGINAL